

WHAT IS CLAIMED IS:

1. A method of producing a container comprising the steps of:

forming a container in a forming device,

transferring said container to an environmentally controlled area to maintain a predetermined cleanliness level, and

cleaning said container.

2. The method of claim 1, further comprising:

enclosing said container in a second container, and

sterilizing said container.

3. The method of claim 1, wherein said container is formed from glass and said method comprises forming said container in a glass forming device and heating said container to an annealing temperature to simultaneously anneal and clean said container to form said container.

4. The method of claim 1, further comprising filling said container with a desired substance and coupling a closure member to said container to close said container.

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11. The method of claim 10, further comprising annealing said syringe barrel at a temperature of at least about 560°C.

12. The method of claim 1, wherein said environmentally controlled area maintains a cleanliness level of about Class 100.

13. The method of claim 1, wherein said environmentally controlled area comprises at least one housing assembly having an air blower and a HEPA filter coupled to said air blower to filter air entering said at least one housing assembly.

14. The method of claim 13, wherein said at least one housing assembly is maintained at a positive internal pressure to prevent unfiltered air from entering said housing assemblies.

15. The method of claim 6, further comprising applying a coating of a lubricant to an inner surface of said syringe barrel.

16. The method of claim 10, wherein said forming step comprises heating a first end of a glass tube to a temperature whereby said glass tube is pliable and shaping said first end to form a flange extending substantially radially outward from a center axis of said glass tube.

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21. The method of claim 20, wherein said forming step comprises supplying a cylindrical glass tube to said forming device and heating a first end of said glass tube to a temperature whereby said glass tube is pliable and forming a flange about said first open end and heating a second end of said glass tube to a temperature whereby said glass tube is pliable and forming a tip at said second end.

23. The method of claim 21, further comprising annealing said syringe barrels by heating to at least about 560°C.

25. The method of claim 24, wherein said cleaning step comprises directing a stream of filtered, ionized air onto said syringe barrels to remove particulates from surfaces thereof.



31. The method of claim 30, wherein said housing assembly enclosing said forming device maintains a cleanliness level of about Class 100.

32. The method of claim 19, wherein said syringe barrels are immediately transferred to said at least one housing assembly after forming to maintain a predetermined cleanliness standard.

33. A method of producing a filled syringe comprising the steps of:

forming a plastic syringe barrel in an injection molding machine, said syringe barrel having a cylindrical side wall, an open proximal receiving end and a frustoconically shaped outlet nozzle at its distal end;

transferring said syringe barrel, without any additional cleaning or sterilization, into an environmentally controlled area to maintain a predetermined cleanliness level;

directing a stream of filtered air toward said syringe barrel in said environmentally controlled area to remove particles from surfaces thereof to clean said syringe barrel;

delivering a tip cap to said environmentally controlled area;

air cleaning said tip cap in said environmentally controlled area;

assembling said tip cap to said outlet nozzle of said syringe barrel to close said outlet nozzle;

filling said syringe barrel with a substance through its open proximal end;

delivering a stopper to said environmentally controlled area;

inserting said stopper into said open proximal end of said barrel to form a prefilled syringe; and

removing said prefilled syringe from said environmentally controlled area.

34. The method of claim 33, further including the step of packaging said prefilled syringe.

35. The method of claim 33, further including the step of sterilizing said prefilled syringe.

36. The method of claim 33, further including the steps of sterilizing said prefilled syringe followed by the step of packaging said prefilled syringe.



37. A method of producing a filled syringe comprising the steps of:

forming a plastic syringe barrel in an injection molding machine, said syringe barrel having a cylindrical side wall, an open proximal receiving end and a frustoconically shaped outlet nozzle at its distal end;

transferring said syringe barrel, without any additional cleaning or sterilization, into an environmentally controlled area to maintain a predetermined cleanliness level;

directing a stream of filtered air toward said syringe barrel in said environmentally controlled area to remove particles from surfaces thereof to clean said syringe barrel;

delivering a stopper in said environmentally controlled area;

inserting said stopper into said open proximal end of said syringe barrel to close said proximal end;

filling said syringe barrel with a substance through its outlet nozzle;

delivering a tip cap to said environmentally controlled area;

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air cleaning said tip cap in said environmentally controlled area;

assembling said tip cap to said outlet nozzle of said syringe barrel to form a prefilled syringe; and

removing said prefilled syringe from said environmentally controlled area.

38. The method of claims 37, further including the step of packaging said prefilled syringe.

39. The method of claims 37, further including the step of sterilizing said prefilled syringe.

40. The method of claims 37, further including the steps of sterilizing said prefilled syringe followed by the step of packaging said prefilled syringe.

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